

Work Order ID 69320

Monday, May 09, 2011 8:48:54 AM



Page 1

Item ID: D3537-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 5/9/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

H

Date: *11-05-9*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☐ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary

304.003

11-5-9

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-5-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/11

(25)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

SB 11/6/09

8

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

8 11/6/09

8

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
m 117607 Weld hardcoat as per Dwg D3437

X8 11-6-14 JBC/02

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Work Order ID 69320

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Page 4

Item ID: D3537-7

Revision ID:

Item Name: Wearpad

Start Date: 5/9/2011 Start Qty: 8.00

Required Date: 5/12/2011 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: F-P19 0.00

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

8 d 11/10/16

8x d M-2/11/06/16

11/10/16
MF
11-06-16

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 8:49:26 AM

Page 1

Work Order ID: 69320

Parent Item: D3537-7

Parent Item Name: Wearpad



Start Date: 5/9/2011

Required Date: 5/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-03-12 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

96.0000

0.15

1.263158



1311-5-9

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

96

117275

96

117075

(8)

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SHOP COPY
RETURN TO
ENGINEERING

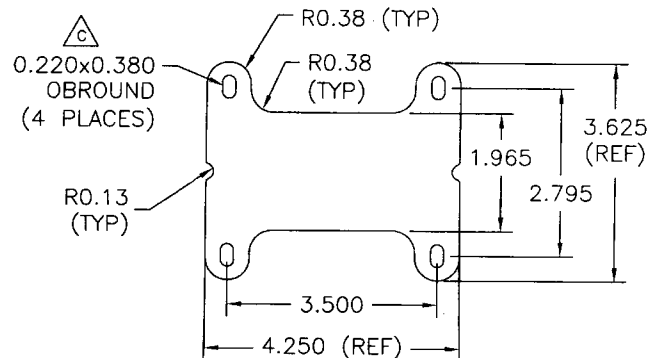
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

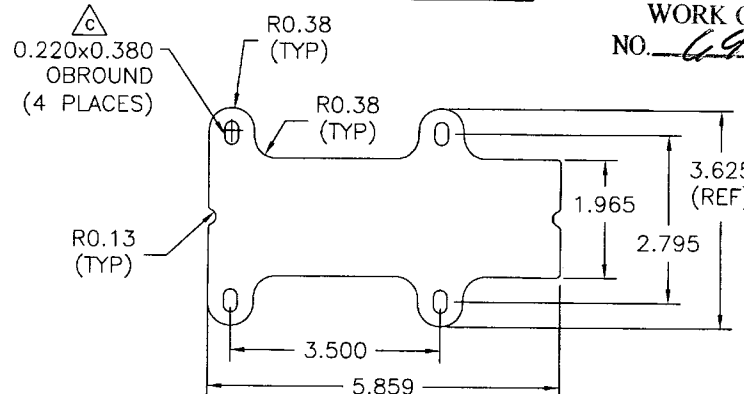
NO. 69320

11-05-9

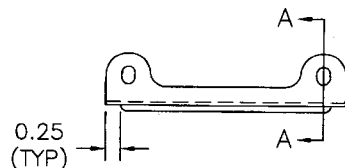
D3537-1F FLAT PATTERN



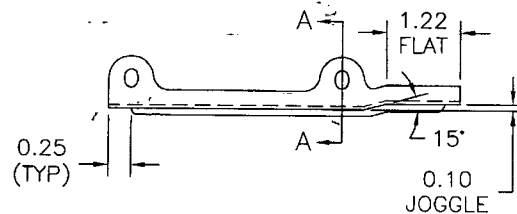
D3537-3F FLAT PATTERN



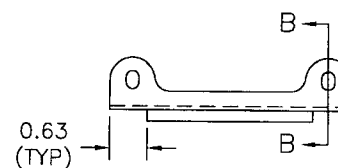
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



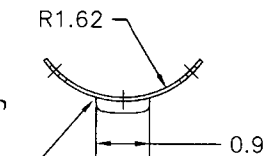
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)

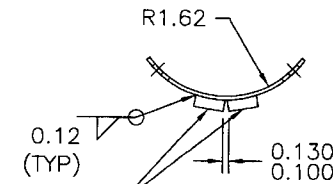


SECTION A-A



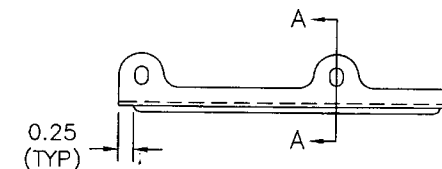
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08 per ECU 962

W/O:		WORK ORDER CHANGES							
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